

Date: Thursday, 3/8/2007 1:11:59 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: WEARSHOE		
Job Number	: 31113			Part Number	: D265615		
Estimate Number	: 10613			Drawing Number	: D2656 REV D		
P.O. Number	: N/A			Project Number	: N/A		
This Issue	: 3/8/2007 S.O. No. : N/A			Drawing Revision	: D		
Prsht Rev.	: NC			Material	: N/A		
First Issue	: 3/8/2007 Type : PURCHASED PARTS			Due Date	: 3/30/2007 Qty: 20 Um: Each		
Previous Run	: 29335						
Written By							
Checked & Approved By							
Comment	: Est: D 02.10.25 Re-format KJ						
	, Est Rev:E Now on Waterjet 06-09-25 JLM						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :					
1.0	M1010S20GA	1010/1025/A21/6aA SHEET			SAD	07/05/27	20
2.0	WATER JET	FLOW WATER JET			SAD	07/05/27	20
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE			SAD	07/05/27	20
4.0	QC8	SECOND CHECK			SAD	07/05/27	20
5.0	BRAKE NC	NC BRAKE			SAD	07/06/21	20

Comment: Qty.: 0.6431 sf(s)/Unit Total : 12.8625 sf(s)
 1010/1025/A21/6aA SHEET (.040")
 (M1010S20GA)
 Batch: M103453

Comment: FLOW WATER JET
 1-Cut as per Dwg D2656
 Dwg Rev: D
 Prog Rev: D

2-Deburr if necessary

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Comment: SECOND CHECK

Comment: NC BRAKE
 1-Form on Brake as per Dwg D2656 using Jigs DT8261and DT8326
 2-Form joggle as per Dwg D2656 using Jig DT8158
 3-Identify as D2656-15

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 07/06/02
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 3/8/2007 1:12:00 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARSHOE

Job Number: 31113

Part Number: D265615

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



Contd

Comment: INSPECT WORK TO CURRENT STEP

7.0 POWDER COATING

POWDER COATING



M 101601



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

BR/M-2 07-08-21

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

F2

07/06/22. 20

9.0 PACKAGING 1

PACKAGING RESOURCE #1



20X

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

F-P - 14

m.d 07/06/22

20

10.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/06/22

Job Completion



u 07.06.22

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

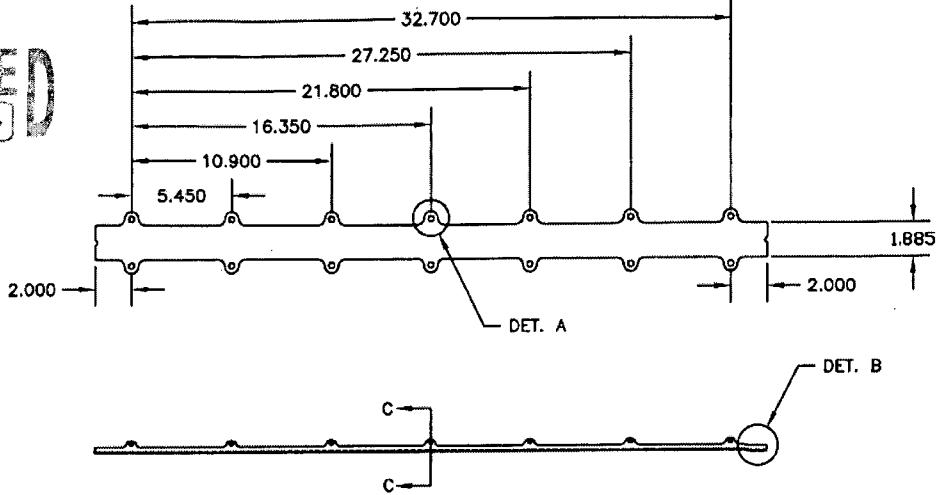
NOTE: Date & initial all entries



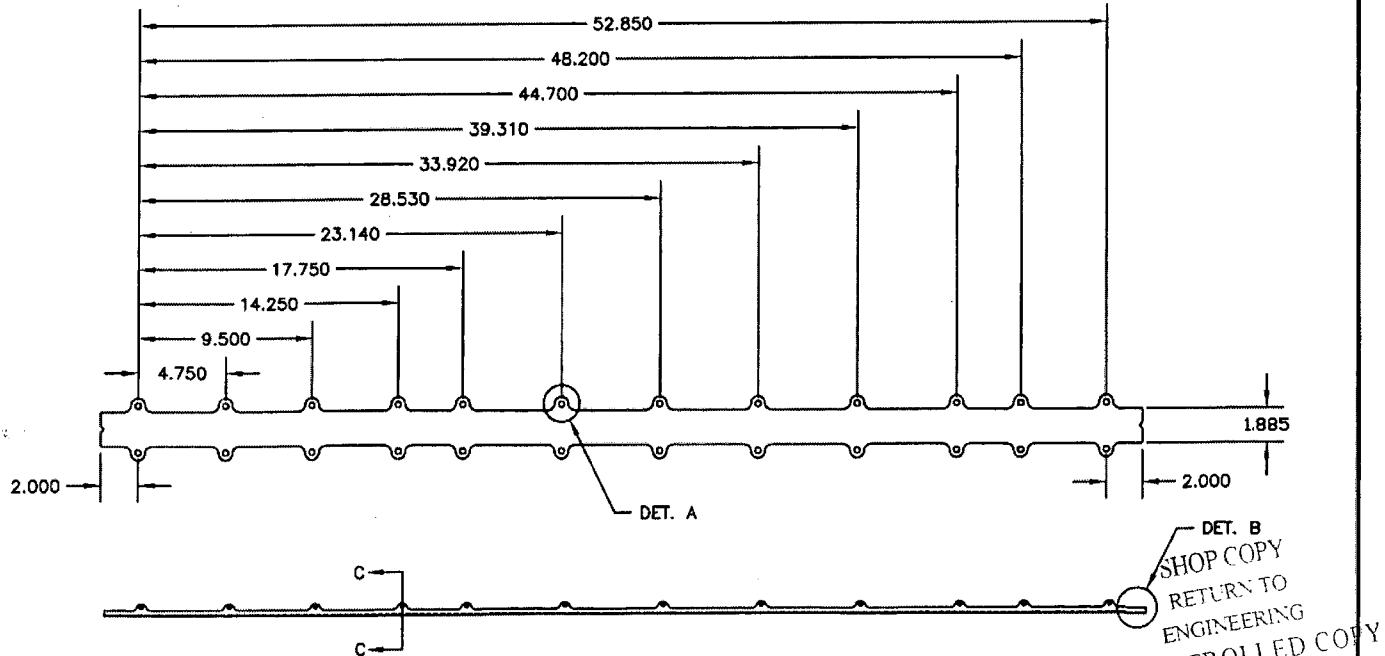
DESIGN DS	DRAWN BY CP	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2656
DATE 05.08.17	TITLE WEARSHOE	REV. D SHEET 2 OF 4 SCALE 1:10

D2656-21

RELEASED
05.09.06 *[Signature]*



D2656-23



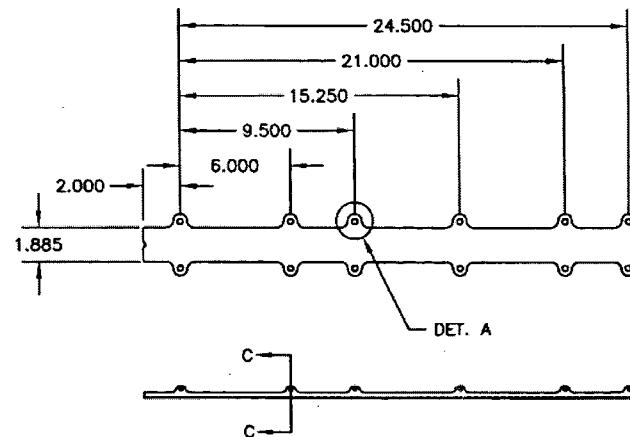
NOTES

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W
SERIES STEEL, 20 GAUGE (0.040 THICK)
FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER QSI 005 4.3
TOLERANCES ARE PER DART QSI 018
UNLESS OTHERWISE NOTED

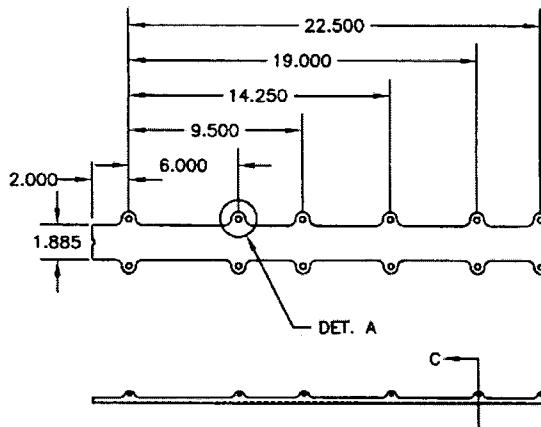


DESIGN	DS	DRAWN BY	CP	DART AEROSPACE USA, INC.
CHECKED	<input checked="" type="checkbox"/>	APPROVED	<input checked="" type="checkbox"/>	PORT HADLOCK, WA
DATE	05.08.17	DRAWING NO.	D2656	REV. D
		SHEET 3 OF 4		SCALE 1:10

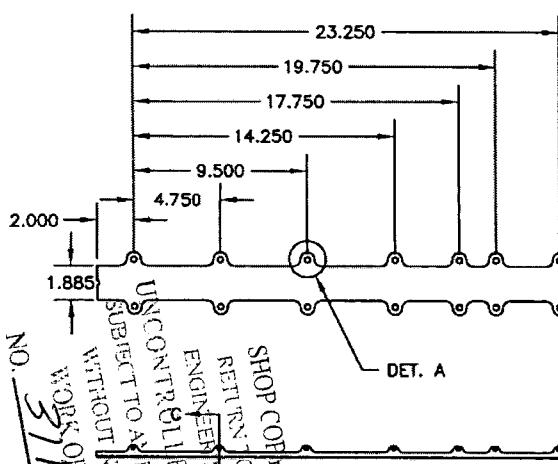
D2656-33



D2656-31

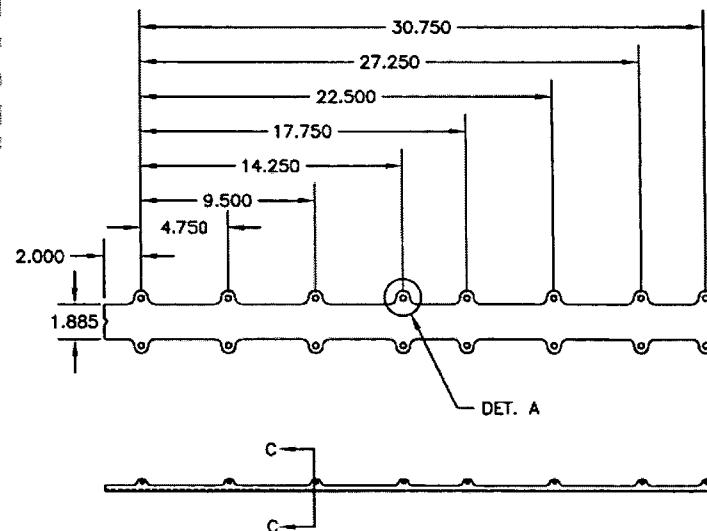


D2656-35



RELEASED
05.07.06
H

D2656-37



NO. 37113

NOTES

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W
SERIES STEEL, 20 GAUGE (0.040 THICK)

FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3

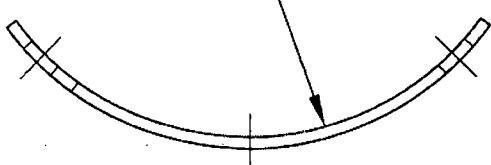
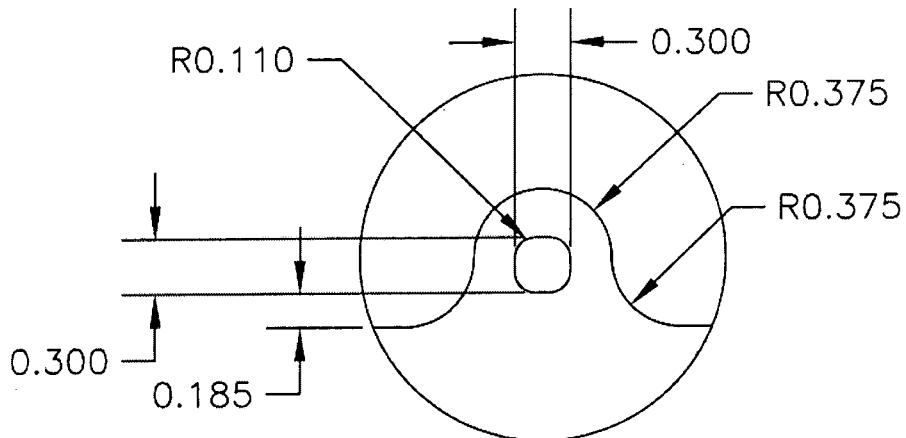
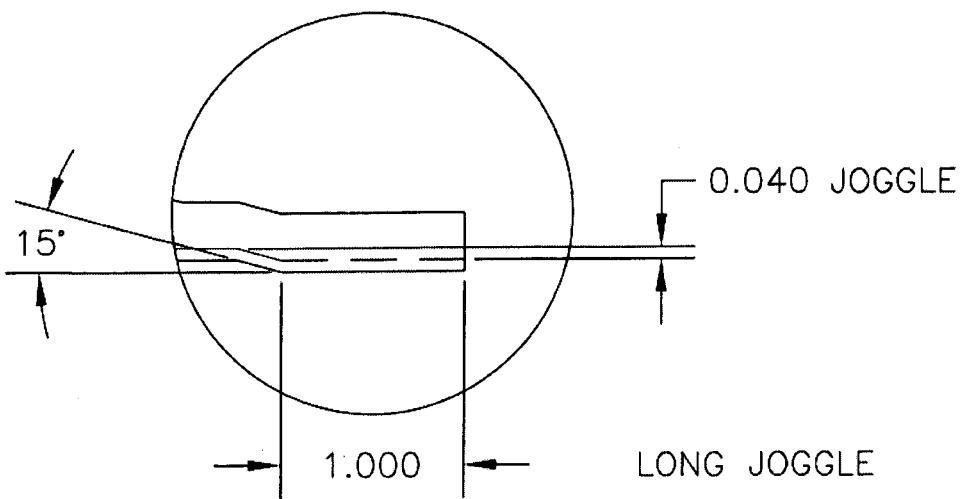
TOLERANCES ARE PER DART QSI 018
UNLESS OTHERWISE NOTED

DART

DESIGN DS	DRAWN BY CP	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>AA</i>	APPROVED <i>AA</i>	DRAWING NO. D2656	REV. D SHEET 4 OF 4
DATE 05.08.17		TITLE WEARSHOE	SCALE 1:10

SECTION C-C

R1.62

**RELEASED**
05.09.06 *AA*DETAIL ADETAIL B

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *31173*

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DART AEROSPACE LTD

Work Order: 31113

Description: WEARSHOE

Part Number: D265615

Inspection Dwg: D2656 Rev: D

Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST



First Article



Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A 39.150	+/- 0.010	39.150	/		M-T	
B 35.650	+/- 0.010	35.650	/		M-T	
C 33.650	+/- 0.010	33.650	/		M-T	
D 30.150	+/- 0.010	30.150	/		M-T	
E 24.900	+/- 0.010	24.900	/		M-T	
F 19.650	+/- 0.010	19.650	/		M-T	
G 14.400	+/- 0.010	14.400	/		M-T	
H 9.150	+/- 0.010	9.155	/		Vern	
I 5.650	+/- 0.010	5.652	/		Vern	
J 2.000	+/- 0.010	2.005	/		height gage	
K 1.895	+/- 0.010	1.891	/		Vern	
L 0.300	+/- 0.010	0.301	/		Vern	
M 0.300	+/- 0.010	0.299	/		Vern	
N 0.040	+/- 0.010	0.035	/		Vern	
O						
P						
Q						
R						
S						
T						
U						
V						
W						
X						
Y						

Measured by: JAD

Audited by: SG

Prototype Approval: N/A

Date: 07/05/26

Date: 07.05.27

Date: N/A

Rev	Date	Change	Revised by	Approved
		New Issue	KJ/RF	

